

Work Order ID 60475

Monday, July 12, 2010 1:18:10 PM



Page 1

Item ID: D4035-043

Accept



Setup Start



Revision ID:

Item Name: Lid Rib Assembly, Aft (350 Basket)

Stop



Start Date: 7/12/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/16/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *R*Date: *7/12*

Tooling:

Date:

Run Start



QC: _____

Date: _____

SPC (Y/N):

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4035

A

100

Weld per dwg A/R S.S. rod Batch: _____ 0.00



Large Fab

Memo

0.00

(2) 10.07.21

Large Fab

- 1- Cut D4035-3 as per dwg D4035
- 2- Drill holes using DT9563 and chamfer holes as per dwg D4035
- 3- remove identification marks and deburr
- 4- Weld bushing in rib and grind weld flush as per dwg D4035

SAO 10-07

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

(2) PD 10.07.22

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Setup Start



Revision ID:

Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 7/12/2010 Start Qty: 2.00



Stop



Required Date: 7/16/2010 Req'd Qty: 2.00



Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

S1060722

(x2)

130



Packaging

Packaging

Identify as per dwg & Stock Location: WA

0.00

SAO

10-07-22

(2)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/07/23 JF

JF
10-7-22

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Picklist Print

Monday, July 12, 2010 1:18:15 PM

Page 1

Work Order ID: 60475



Parent Item: D4035-043



Parent Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 7/12/2010

Required Date: 7/16/2010

Comments: IPP revA: new issue DD 09.11.25 verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4021-9 		Manufactured	No			100	Each	10.0000	2	4		<i>Jd 10-07-21</i>	

Bushing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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WA	10	
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56094	2	
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59838	8	
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M304TS0.750W.049



304 SQ Tube .75x.75x.049W

Purchased

No

100	f	260.5234	1.75
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	3.684211
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<i>(4)</i>	
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<i>SAD</i>	
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<i>10-07-14</i>	
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<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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MAT	44.73396794	
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113763	0	
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114323	23.9557189	
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114677	14.34201	
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114835	6.436239	
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MAT017	3.68448E-05	
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114298	3.6845E-05	
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WA	215.7894	
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114992	215.7894	
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<i>3.6842</i>	
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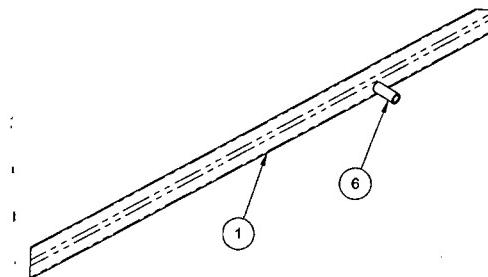
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ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7		1			D2953-175	SPACER
8	2				D4021-9	BUSHING



D4035-041 BASKET LID RIB ASSY, FWD

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COP

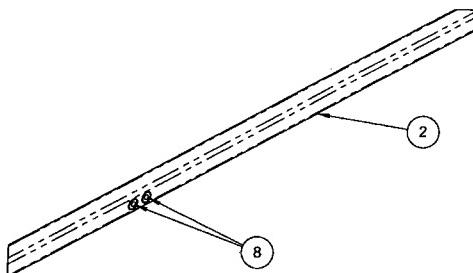
SUBJECT TO AMENDMENT

WITHOUT NOTICE

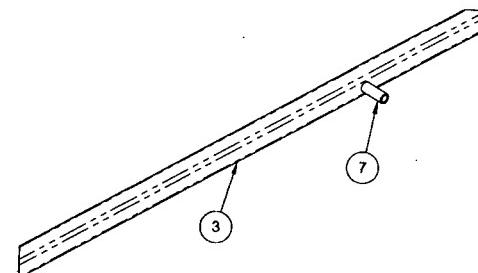
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NO. 60475

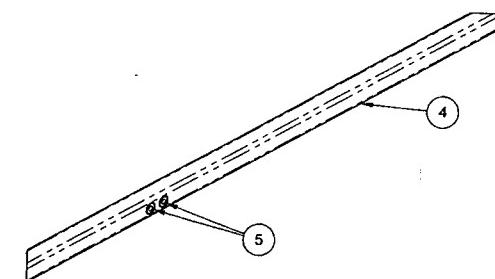
BD10-712



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12
AM

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		D4035	
APPROVED		REV. A	
DE APPR.		SHEET 1 OF 5	
DATE	10.03.04	SCALE	NTS
BASKET LID RIB ASSY			

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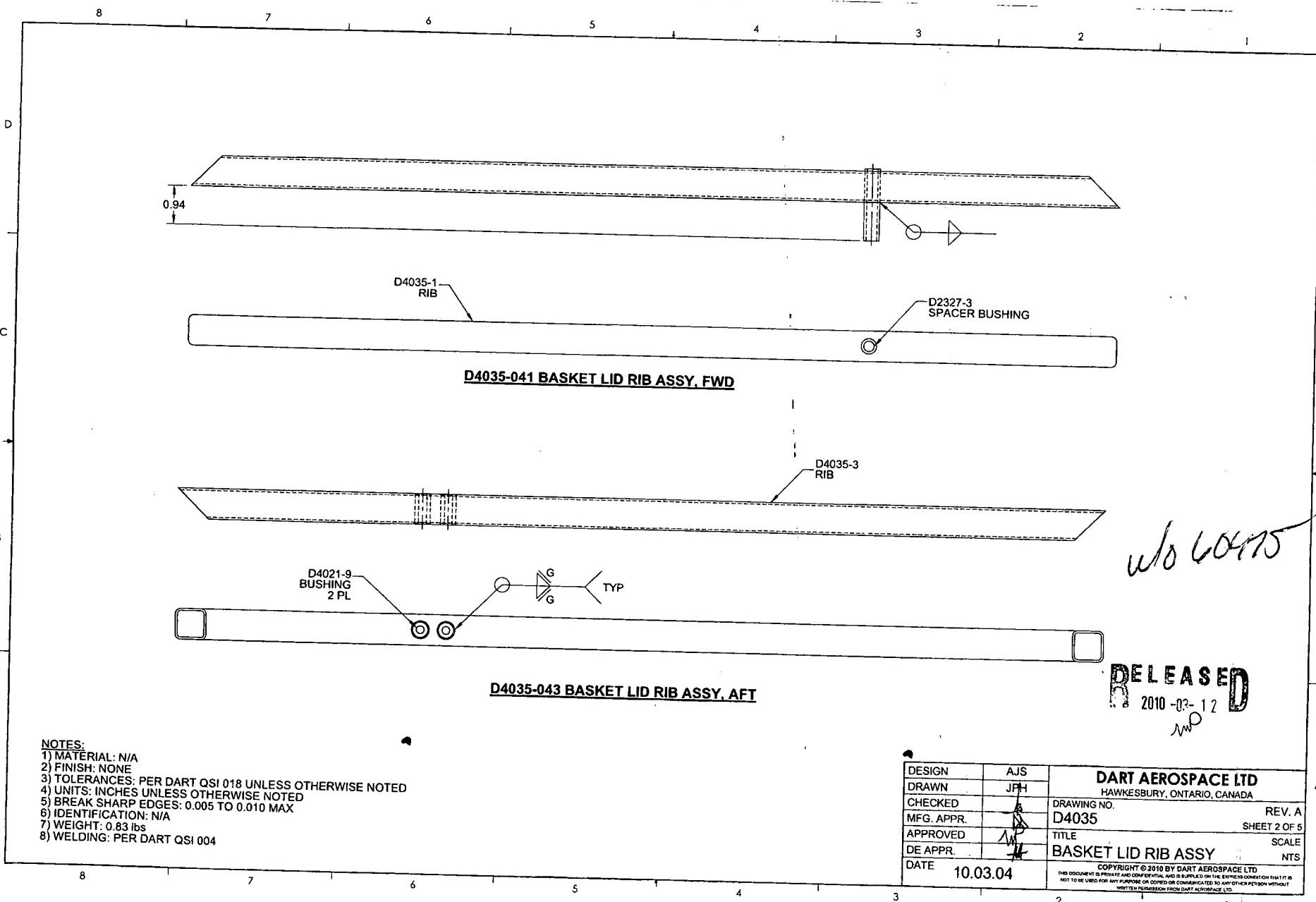
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DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AM</i>	DRAWING NO.	
MFG. APPR.		REV. A	
APPROVED	<i>AM</i>	D4035	
DE APPR.	<i>AM</i>	SHEET 2 OF 5	
DATE	10.03.04	TITLE	SCALE
		BASKET LID RIB ASSY	
		NTS	

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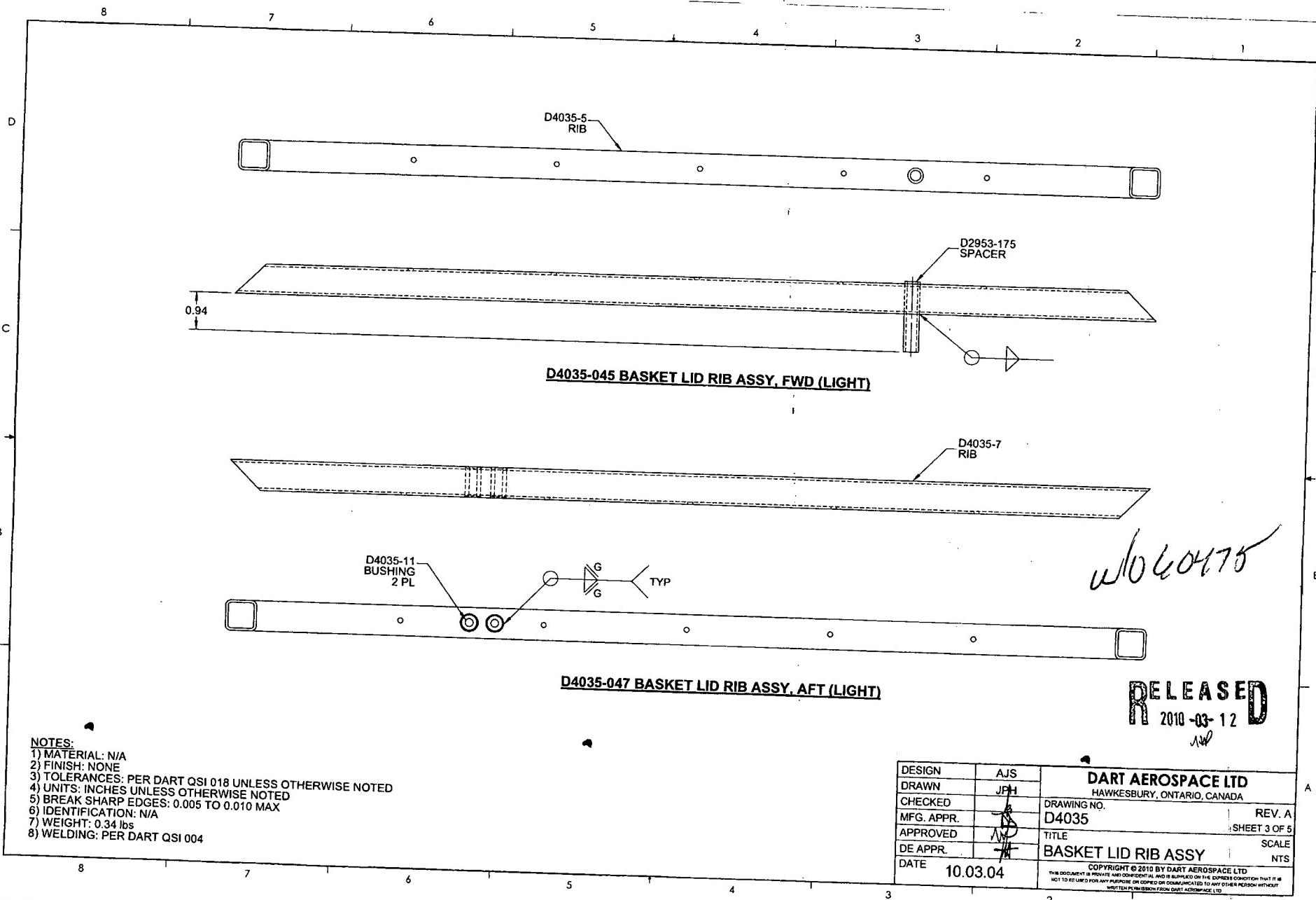
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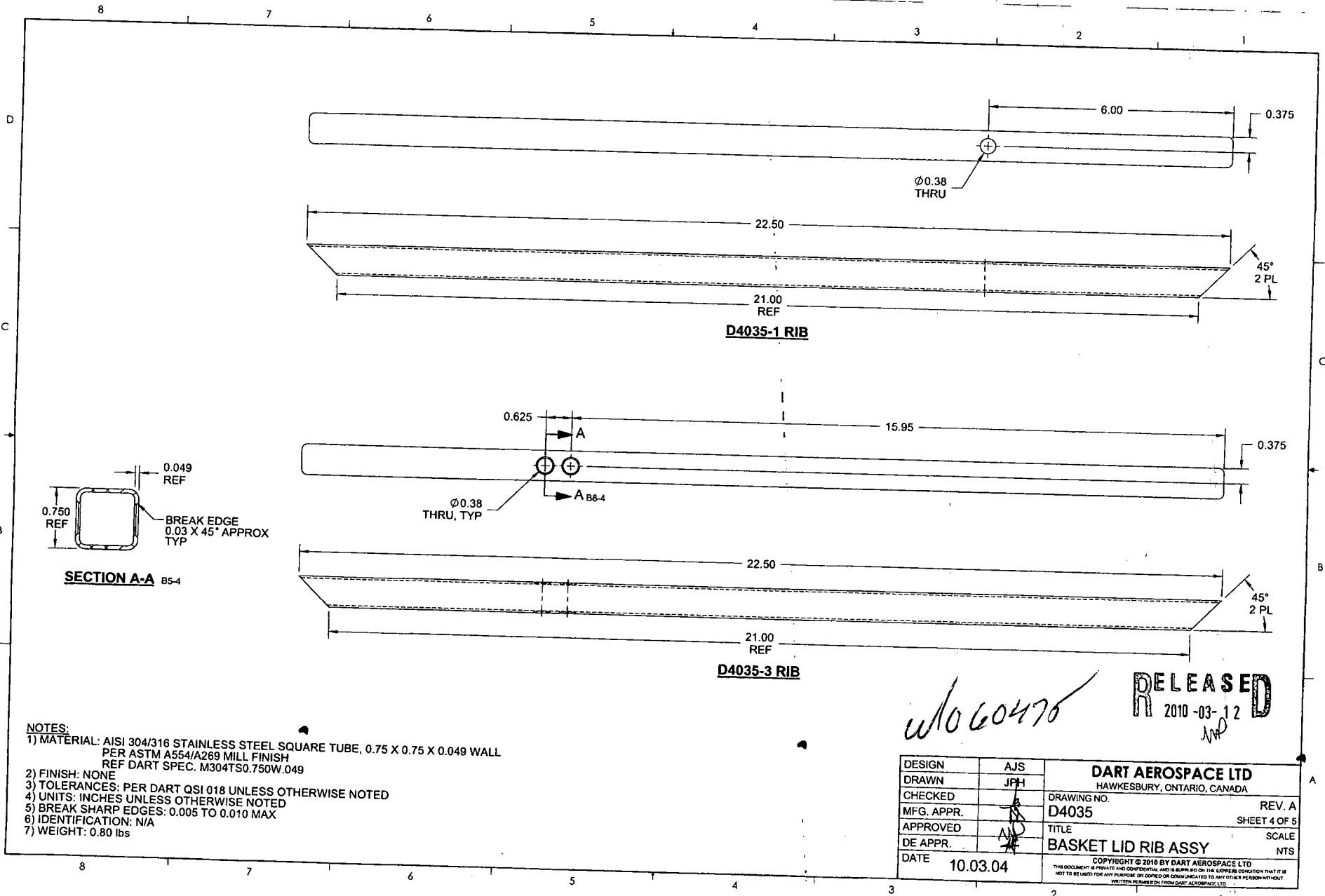
RELEASED
2010-03-12
JPH

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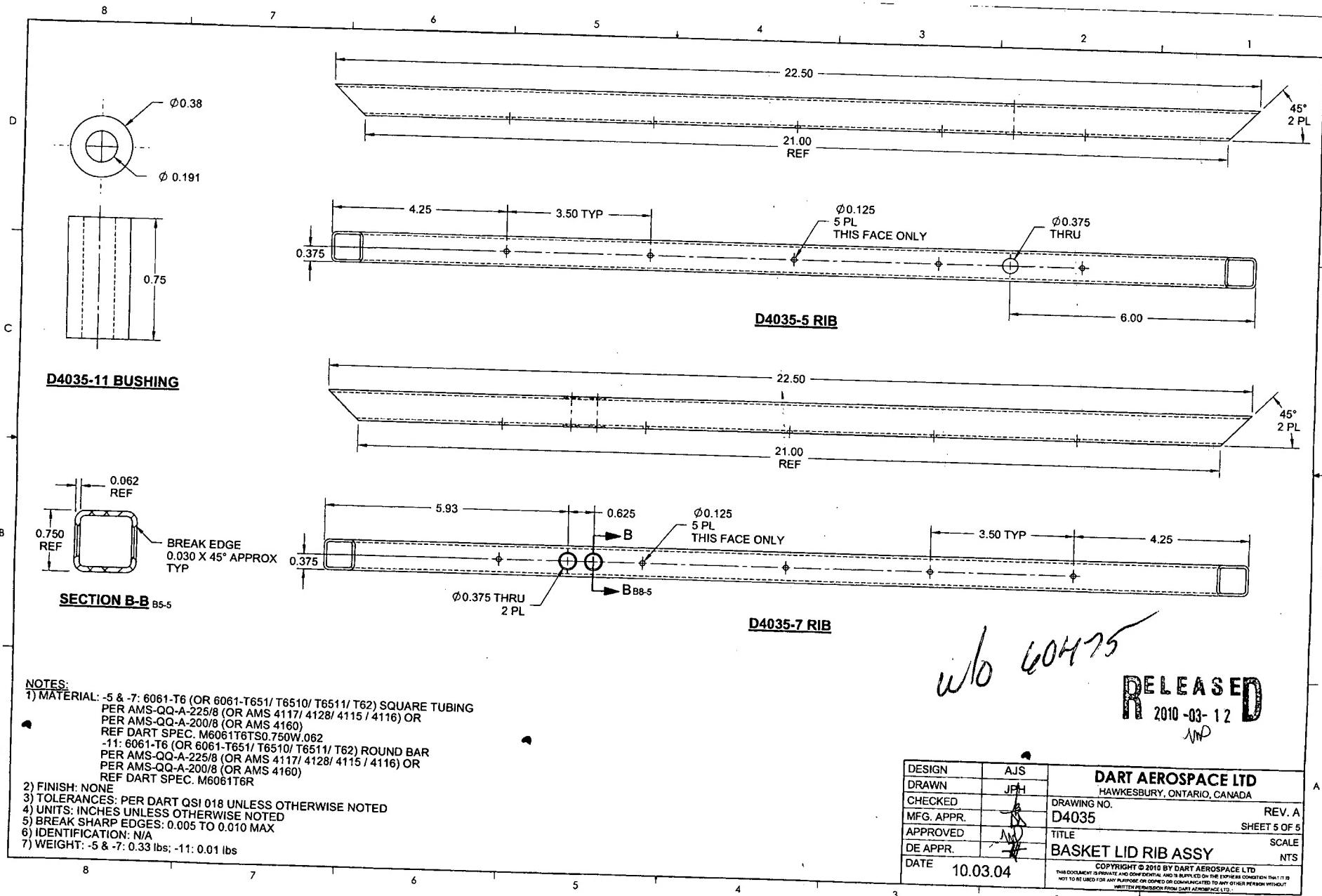
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